

\_\_\_\_\_

Page 1

**Accept**



**Setup Start**

**Stop**

[illegible]**Cust Item ID:**[illegible]

**Customer:**

**Reference:**

MF

Date: 11-09-20

**Tooling:**

Date:

Run Start

**QC:**

Date:

**SPC (Y/N):**

Date:

**Stop**

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73953**

Tuesday, September 20, 2011 10:17:02 AM



Page 2

Item ID: D3529-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 9/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

11/10/20

4

x

Quality Control

150

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

PPA 73952

11/10/21 (4)

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/10/21

Quality Control

P11-10-20  
G

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 20, 2011 10:17:00 AM

Page 1

Work Order ID: 73953



Parent Item: D3529-1



Parent Item Name: Bearpaw

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-06-28 JLM  
IPP Rev:B New Manufacturing Method 08-11-27 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MUHMWB10

Purchased

No

100

sf

623.6200

1.265

5.326316



B11-930

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT018

383.62

117321

76.6

117738

124.3

117819

99.3

118257

83.42

ST

240

118814

240

118814

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	73953
Description: Bearpaw		Part Number:	D3529-1
Inspection Dwg: D3529 Rev: A		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.50	+/-0.030	5.495	✓		Vern FKO4	
B	0.07 x 45°	+/-0.030 x 0.5°	.07 x 45°	✓		"	
C	R0.25	+/-0.030	.25	✓		rad gauge	
D	0.250	+/-0.010	.253	✓		Vern FKO4	
E	0.625	+/-0.010	.620	✓		"	
F	0.950	+/-0.010	.944	✓		"	
G	1.63	+/-0.030	1.62	✓		"	
H	12.14	+/-0.030	12.15	✓		Tape FKO5	
I							
J	5.70	+/-0.030	5.70	✓		Vern FKO4	
K	0.375	+/-0.010	.375	✓		"	
L	0.525	+/-0.010	.530	✓		"	
M	0.13 x 45°	+/-0.030 x 0.5°	.160 x 45°	✓		"	
N	R0.50	+/-0.030	.50	✓		rad gauge	
O	12.76	+/-0.030	12.775	✓		Tape FKO5	
P	3.38	+/-0.030	3.38	✓		Vern FKO4	
Q	3.75	+/-0.030	3.75	✓		"	
R	5.187	+/-0.010	5.189	✓		"	
S	5.25	+/-0.030	5.25	✓		"	
T	7.13	+/-0.030	7.13	✓		Tape FKO5	
U	Ø0.260	+0.006/-0.001	.260	✓		Vern FKO4	
V	0.30	+/-0.030	.317	✓		"	
W	0.93	+/-0.030	.93	✓		"	
X	1.30	+/-0.030	1.30	✓		"	

Measured by:	FK / SL
Date:	11/10/19.

Audited by:	amf
Date:	11/11/20

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.05.06	Dimension I removed	KJ/DD	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

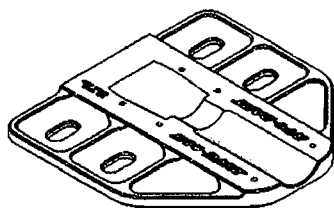
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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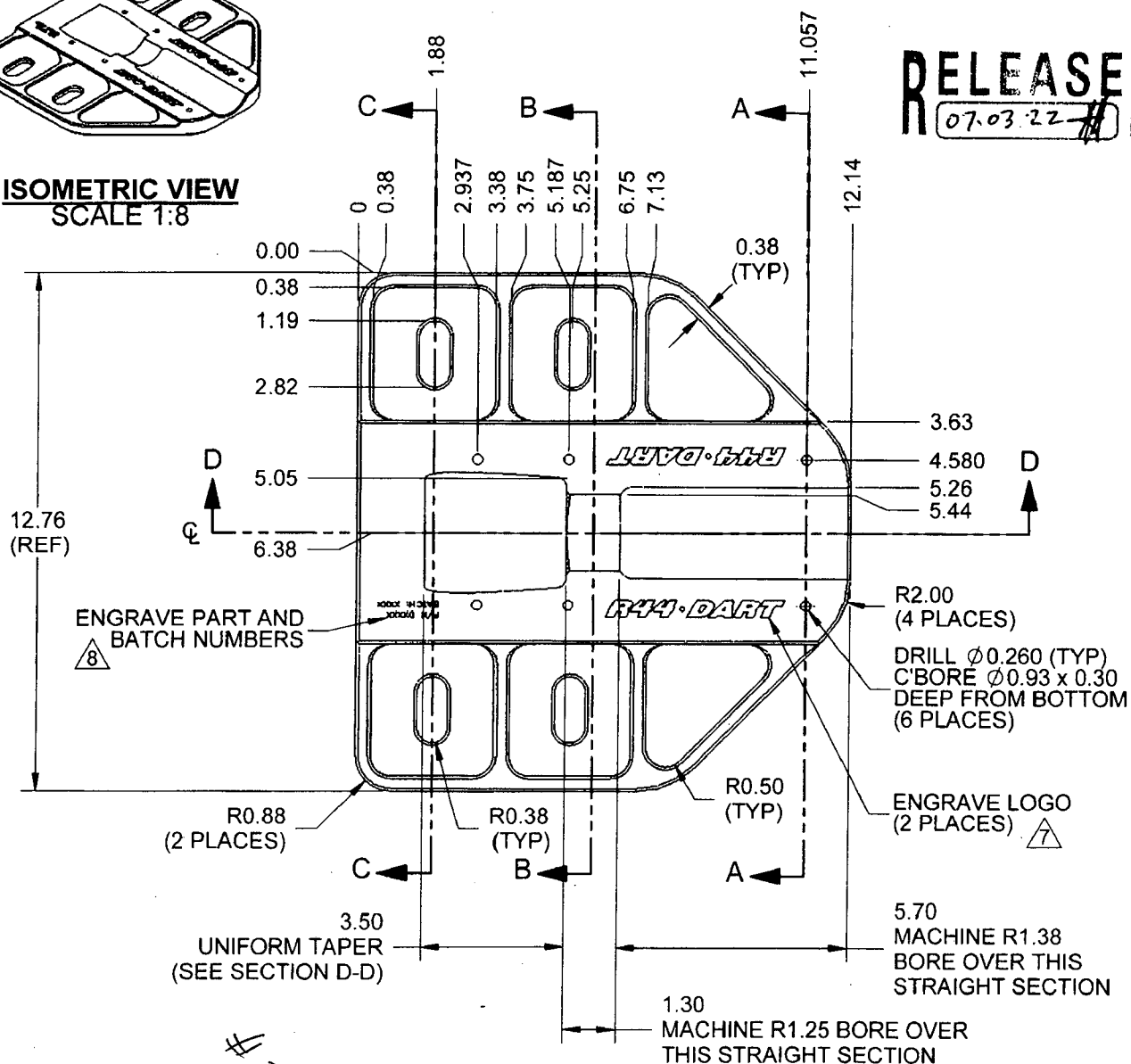


DESIGN CB	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. <b>D3529</b>	REV. A SHEET 1 OF 2
DATE <b>07.01.04</b>		TITLE <b>R44 BEARPAW</b> SCALE 1:4	
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	



**ISOMETRIC VIEW**  
**SCALE 1:8**

RELEASED  
07.03.22



**D3529-1 R44 BEARPAW**

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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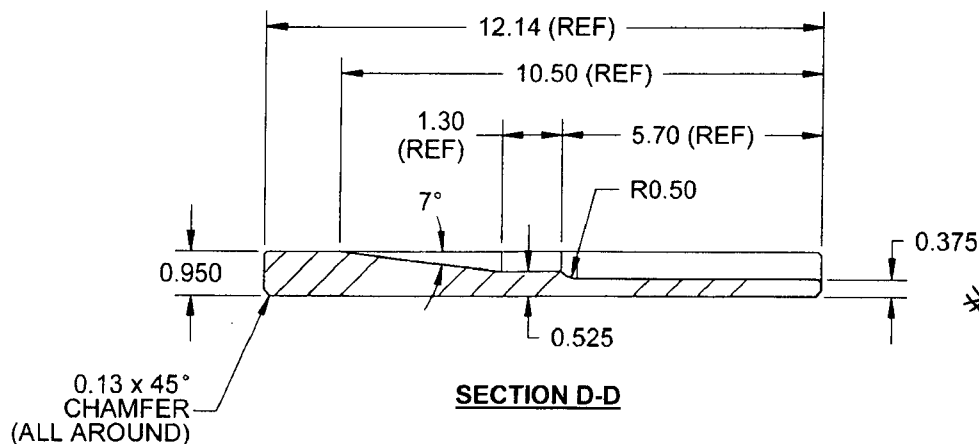
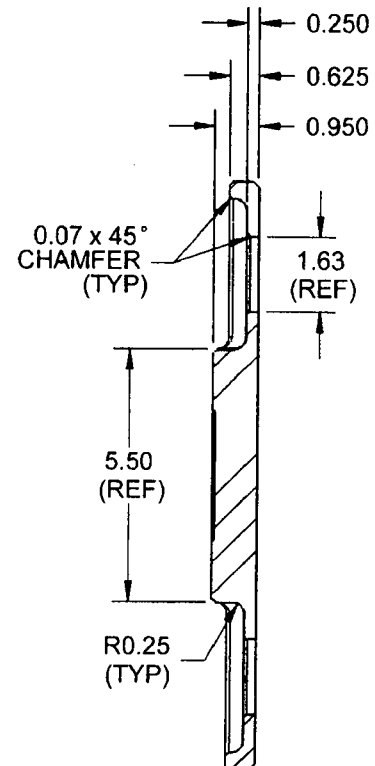
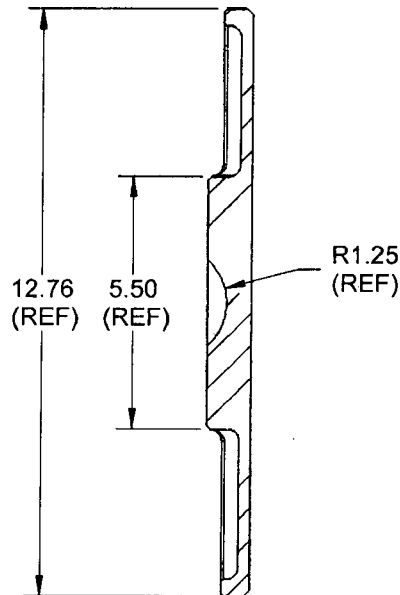
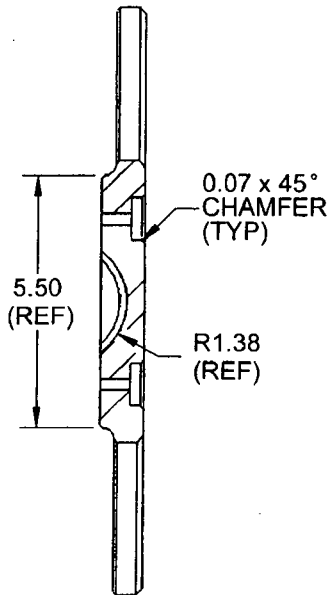
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**DART**

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4

**RELEASED**  
07.03.22

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